

DART SERVICE INSTRUCTION

TO AMEND

INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-748 Rev. 1

REF. CANADIAN STC: SH06-27

REF. FAA STC: SR02359NY

REF. EASA STC: EASA.10016903

PURPOSE:

For D350-748-101/-201 High Crosstubes at CHG 003 or later, the D2856-400-710 Abrasion Strips have been removed and the D3502-1 Supports have been installed with Proseal 890.

CHANGE:

The parts list in Section 32.8 of ICA-D350-748 Rev. 1 is updated as follows:

32.8 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT

WAS

*2	*2	D2856-400-710	ABRASION STRIP
*2	*2	MS21920-20	CLAMP

IS:

*2	*2	D3595-063-395	RUBBER CUSHION
*2	*2	MS21920-22	CLAMP (OR MS21920-21)
*A/R	*A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

The support installation procedure in Section 32.4 of ICA-D350-748 Rev. 1 is updated as follows:

32.4 SUPPORT INSTALLATION

Note: If installing supports on D350-748-101/-201 at CHG 002 or earlier, it is recommended that the D2856-400-710 Abrasion Strips at the support locations be removed in accordance with Section 32.5 of ICA-D350-748 Rev. 1 and the supports be installed as outlined below.

- 32.4.1 Locate the area on the crosstube for installation of support (see Figure 1 of this service instruction). Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.2.12) of ICA-D350-748.
- 32.4.2 Abrade the mating surface of support with 180-grit sandpaper. Abrade the mating surface of the crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Apply a 0.02" to 0.05" thick layer of Proseal 890 Class B or AMS-S-8802 Class B sealant underneath applicable support and install support as shown in Figure 1 of this service instruction.
- 32.4.4 Install the clamps on support as shown in the section A-A of Figure 1 of this service instruction. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 60-80 in-lb (6.8-9.0 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps; ensure that the nuts are in safety but not bottomed out after torquing the clamps per this instruction.
- 32.4.5 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	12.10.10
CERT. NO.:	SH06-27
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9634	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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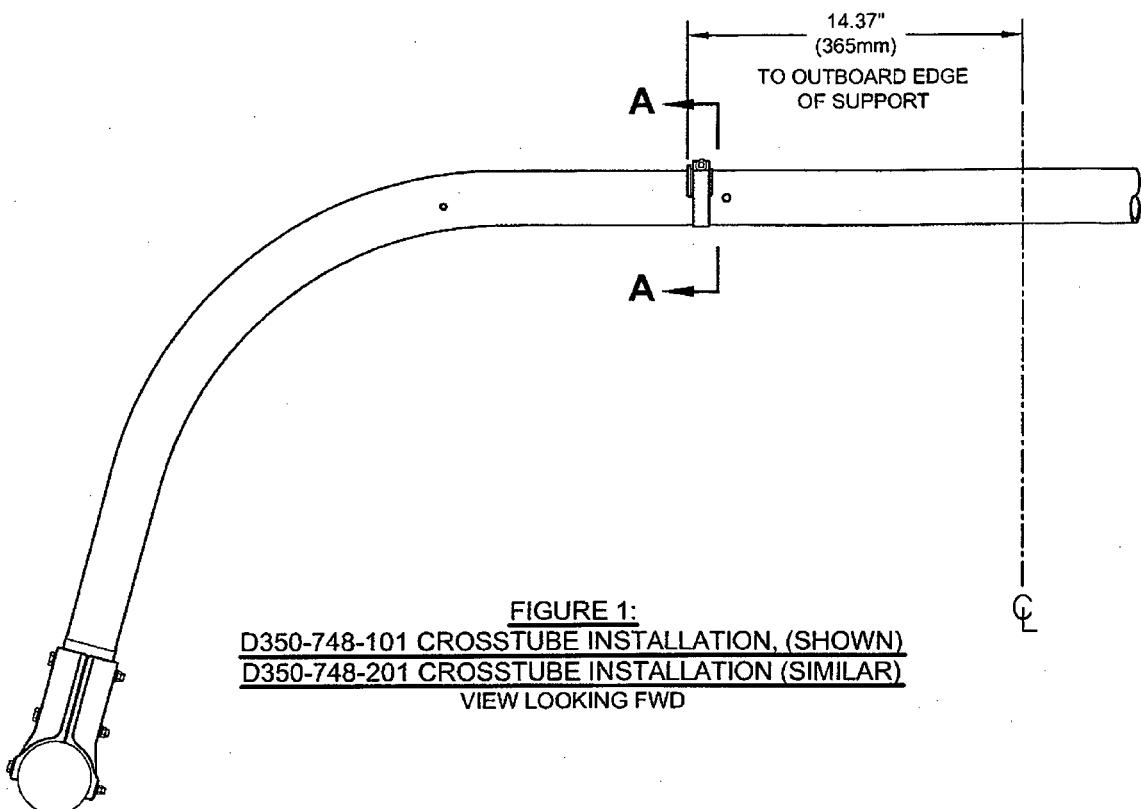
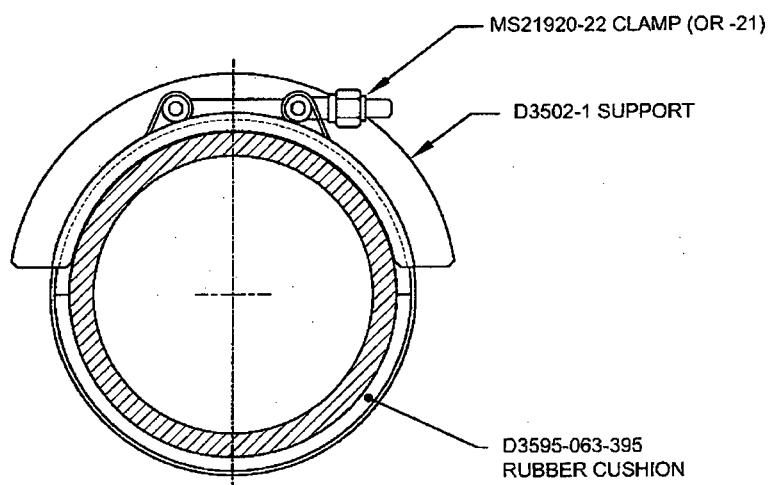


FIGURE 1:
D350-748-101 CROSSTUBE INSTALLATION, (SHOWN)
D350-748-201 CROSSTUBE INSTALLATION (SIMILAR)
 VIEW LOOKING FWD



SECTION A-A
 SCALE 6X

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH	
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BY:	<i>[Signature]</i>
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DESIGN	<i>SP</i>	DART AEROSPACE LTD	
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CHECKED	<i>[initials]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9634	SHEET 2 OF 2
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